

Work Order ID 111858

January-23-14 2:42:08 PM

Page 1

Correct pick list as per Harry Ship 14-03-14
*4/14/14 04:10 *111858**

Item ID: E205-828-011
 Revision ID:
 Item Name: Dual Hydraulic Collective Control System
 Start Date: 24/01/2014 Start Qty: 5.00
 Required Date: 28/02/2014 Req'd Qty: 5.00
 Reference:

Accept *N900040100* Setup Start *NS1*
 Stop *NS2*
 Cust Item ID:
 Customer:

Approvals: Process Plan:  Date: _____
 QC: _____ Date: _____

Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____

Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-E205-828	A

100 DOCUMENT CONTROL

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP E205-828-011 CHG001

0.00

DAS
06
9-89

APR 10 2014

0.00

110 Pick Kit

110

Packaging

Packaging

Memo

0.00

0.00

DAS
32
9-89

14/2/14 (S)



120 QC4- 100% Inspect kits for completeness

120

QC

Quality Control

Memo

0.00

0.00

DAS
06
9-89

APR 10 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 111858

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111858

Page 2

Item ID: E205-828-011
Revision ID:
Item Name: Dual Hydraulic Collective Control System
Start Date: 24/01/2014 Start Qty: 5.00
Required Date: 28/02/2014 Req'd Qty: 5.00
Reference:

Accept ***N900040100*** Setup Start ***NS1***
Stop ***NS2***
Cust Item ID:
Customer:

Approvals: Process Plan: _____ Date: _____
QC: _____ Date: _____

Tooling: _____ Date: _____
SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP E205-828-011 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

APR 10 2014 06 09-89

[Signature]

MCS 14-04-10

u 14-04-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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January-23-14 2:42:13 PM

Work Order ID: 111858

111858

Parent Item: E205-828-011

F205-828-011

Parent Item Name: Dual Hydraulic Collective Control System

Start Date: 24/01/2014

Required Date: 28/02/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.12.04 NEW ISSUE DD VERF:JLM

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Doc/Data									
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Operator									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 111858

111858

Parent Item: E205-828-011

F205-828-011

Parent Item Name: Dual Hydraulic Collective Control System

Start Date: 24/01/2014

Required Date: 28/02/2014

Start Qty: 5.00

Required Qty: 5.00

SX E4736-043 ***F4736-043*** DAS
Service Deck Drain Line Assembly 06
9-89

SX E4736-045 ***F4736-045*** DAS
Fuel Filter Drain Line Assembly 06
9-89

SX E4736-047 ***F4736-047*** DAS
Vent Line Assembly 06
9-89

SX E4736-049 ***F4736-049*** DAS
Service Deck Drain Line Assembly 06
9-89

SX E4752-1 ***F4752-1*** DAS
Washer 06
9-89

SX E4752-3 ***F4752-3*** DAS
Spacer 06
9-89

SX AN174-14 ***AN174-14*** DAS
BOLT 06
9-89

Manufactured No

Manufactured No

Manufactured No

Manufactured No

Manufactured No

Manufactured No

Purchased No

110 Each 0.0000

110 Each 0.0000

110 Each 0.0000

110 Each 0.0000

110 Each 0.0000

110 Each 0.0000

110 Each 10.0000

1 5
** 111850 DAS 28 9-89 APR 03 2014

1 5
** 111848 DAS 28 9-89 DAS 32 9-89

1 5
** 111847 DAS 32 9-89 DAS 32 9-89

1 5
** 111846 DAS 28 9-89 DAS 32 9-89

1 5
** 111844 DAS 28 9-89 DAS 32 9-89

1 5
** 111845 DAS 32 9-89 DAS 32 9-89

2 10
** 14128300 DAS 32 9-89 14/2/14 5

122378 74

Location

Loc Qty

Loc Code

ST347

10

122378

10

January-23-14 2:42:13 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

January-23-14 2:42:13 PM

Work Order ID: 111858

111858

Parent Item: E205-828-011

F205-828-011

Parent Item Name: Dual Hydraulic Collective Control System

Start Date: 24/01/2014

Required Date: 28/02/2014

Start Qty: 5.00

Required Qty: 5.00

AN3-3A

Purchased

No

110

Each

493.0000

10

DAS
32
9-89

AN3-3A
Bolt

DAS
06
9-89

**

Location

Loc Qty

Loc Code

st350

243

m126249

43

m127044

200

m127815

250

126249

DAS
32
9-89

AN3-6A

Purchased

No

110

Each

246.0000

90

DAS
32
9-89

AN3-6A
Bolt

DAS
06
9-89

**

Location

Loc Qty

Loc Code

ST511

246

M127044

246

m127044

DAS
32
9-89

AN316C6R

Purchased

No

110

Each

100.0000

5

DAS
32
9-89

AN316C6R
NUT

DAS
06
9-89

**

Location

Loc Qty

Loc Code

ST343

100

108038

100

108038

DAS
32
9-89

AN924-4D

Purchased

No

110

Each

9.0000

5

DAS
32
9-89

AN924-4D
Nut

DAS
06
9-89

**

Location

Loc Qty

Loc Code

ST326

9

114935

9

114935

DAS
32
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 4

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111858

Parent Item: E205-828-011

F205-828-011

Parent Item Name: Dual Hydraulic Collective Control System

Start Date: 24/01/2014

Required Date: 28/02/2014

Start Qty: 5.00

Required Qty: 5.00

AN924-6D

Purchased

No

110

Each

47.0000

1

5

DAS
32
9-89

**

14/2/14 (5)

AN924-6D

Nut

Location

Loc Qty

Loc Code

ST326

47

m127044

24

m127290

23

DAS
06
9-89

DAS
06
9-89

m127290

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Shop Packet Print

Page 4

DQA: _____ Date: _____



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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Qty -011	Part Number	Description
1 ^c	70-012H000X184	HOSE ASSY
2	AN174-14	BOLT
2	AN3-3A	BOLT
18	AN3-6A	BOLT
1	AN316C6R	NUT
1	AN737TW44	CLAMP
1	AN814-4DL	PLUG
1	AN814-8WL	PLUG
1	AN924-4D	NUT
1	AN924-6D	NUT
1	AS1005W060606	TEE (ALT. P/N MS21905W6)
1	AS1008W0404	ELBOW (ALT. P/N MS21908W4)
1	AS1008W0606	ELBOW (ALT. P/N MS21908W6)
1	AS5193W06	CROSS (ALT. P/N AN937D6)
1	AS5230W0604	REDUCER (ALT. P/N MS21916W6-4)
2	AS5230W0606	UNION (ALT. P/N MS21902W6)
1	M83461/1-011	PACKING, PREFORMED
1	M83461/1-014	PACKING, PREFORMED
1	M83461/1-110	PACKING, PREFORMED
3	MS14144L5	NUT
1	MS14144L6	NUT
19	MS21042L3	NUT, SELF-LOCKING
1	MS24665-151	PIN, COTTER
4	MS24665-155	PIN, COTTER
8	MS27039-1-10	SCREW
2	MS27647-5	BEARING
5	MS28778-4	PACKING, PREFORMED
4	MS28778-6	PACKING, PREFORMED
6	NAS1149C0563R	WASHER
2	NAS1149D0316J	WASHER
2	NAS1149D0332J	WASHER
8	NAS1149D0363J	WASHER
2	NAS1149D0563J	WASHER
2	NAS1149D0663J	WASHER
2	NAS1149D0763J	WASHER
2	NAS1149D0963J	WASHER
2	NAS1149F0463P	WASHER
1	NAS509-14	NUT
1	NAS551-4DH	BOLT
1	NAS551-6DH	BOLT
1	NAS559-6	LOCK, ROD END

^c Customer supplied item

7.0 PARTS LIST

Qty -011	Part Number	Description
X	E205-828-011	DUAL HYDRAULIC COLLECTIVE CONTROL SYSTEM
1	D212-725-1-901	COLLECTIVE BELL CRANK ASSEMBLY
1	E4702-041	LADDER ASSEMBLY
1	E4706-041	SUPPORT ASSEMBLY
1	E4733-1	BRACKET
1	E4733-3	BRACKET
1	E4733-5	BRACKET
1	E4733-7	BRACKET
1	E4736-041	FUEL FILTER DRAIN LINE ASSEMBLY
1	E4736-043	SERVICE DECK DRAIN LINE ASSEMBLY
1	E4736-045	FUEL FILTER DRAIN LINE ASSEMBLY
1	E4736-047	VENT LINE ASSEMBLY
1	E4736-049	SERVICE DECK DRAIN LINE ASSEMBLY
1	E4752-1	WASHER
1	E4752-3	SPACER
2 ^c	120-032-32-10	SHIM
1 ^c	20-031-12-10	FILLER BLOCK (ALT. P/N 212-030-062-023)
1 ^c	20-057-4-17D	BOLT
3 ^c	20-057-4-21D	BOLT
1 ^c	20-057-4-23D	BOLT
3 ^c	20-057-5-24D	BOLT
1 ^c	20-058-4S15D	BOLT
1 ^c	205-001-047-001	BEARING
1 ^c	205-001-310-001	BOLT
1 ^c	205-076-177-001	NUT
1 ^c	206-001-052-001	BEARING
1 ^c	212-001-059-103	CLEVIS (PART OF 212-001-270-001)
1 ^c	212-001-252-001	TUBE ASSY
1 ^c	212-001-270-001	TUBE ASSY, ADJUSTABLE COLLECTIVE (ALT. P/N 212-001-061-001)
1 ^c	212-001-323-001	BOLT
1 ^c	212-030-062-003	STRUT ASSY
1 ^c	212-030-062-021	STIFFNER
1 ^c	212-076-005-111	CYLINDER ASSY
2 ^c	212-076-015-001	CHECK VALVE
1 ^c	212-076-114-003	ELBOW
1 ^c	212-076-125-003	SPRING
1 ^c	212-076-126-003	CLIP
1 ^c	212-076-146-001	ELBOW
1 ^c	212-076-147-001	CLEVIS
1 ^c	212-076-148-001	CLEVIS
1 ^c	212-076-151-009	TUBE ASSY
1 ^c	212-076-294-001	TUBE ASSY
1 ^c	212-076-297-001	TUBE ASSY
1 ^c	212-076-300-001	TUBE ASSY
1 ^c	212-076-310-001	TUBE ASSY
1 ^c	212-076-328-001	TUBE ASSY
1 ^c	214-001-024-001	INSERT
1 ^c	41000724	FITTING END
1 ^c	412-076-620-101	UNIVERSAL ASSY
2 ^c	70-012F000X204	HOSE ASSY
1 ^c	70-012H000D200	HOSE ASSY

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